



Table 2-1

Sample I.D.	Starting Conditions	#1	#2
POLYMER TYPE	MBM	MBM	
Feeder Setting	2.96	2.96	2.96
water on feeding zone	on	on	on
zone 1 Temp. (deg. c)	245	270	250
zone 2 Temp. (deg. c)	245	280	250
zone 3 Temp. (deg. c)	245	280	250
zone 4 Temp. (deg. c)	245	280	250
zone 5 Temp. (deg. c)	245	280	250
zone 6 Temp. (deg. c)	245	280	250
zone 7 Temp. (deg. c)	245	280	250
8 Connecting Plate Temp. (deg. c)	245	280	250
9 Block Temp. (deg. c)	245	280	250
10 Spin Pump Temp. (deg. c)	245	280	250
11 Top Cap (deg. c)	245	280	250
12 Spin Pack Temp. (deg. c)	245	280	250
Top Heated Sleeve Length (inches)	xxxx	xxxx	xxxx
Top Heated Sleeve Length (deg. c)	xxxx	xxxx	xxxx
Bottom Heated Sleeve Length (inches)	xxxx	xxxx	xxxx
Bottom Heated Sleeve Length (deg. c)	xxxx	xxxx	xxxx
Barrel Melt Temp (deg. c)	252	288	256
Melt Pump Inlet Pressure (psi)	????	420	10
Melt Pump Outlet Pressure (psi)	????	200	470
Extruder (rpm)	200	200	200
Spinneret: no. of holes / Shape	14 R	14 R	14 R
Spinneret: capillary diameter & depth	.024 x 0.072	.024 x 0.072	.024 x 0.072
Metering pump size (cc/rev)	1.16	1.16	1.16
Metering pump (rpm)	16.7	19.3	19.8
Thruput (lbs/hr)	2.97	2.97	2.97
Filter type	STD SCREEN	STD SCREEN	STD SCREEN
Monomer Exhaust Reading (inches water)	TBD	TBD	TBD
Quench air Flow rate (CF/M)	14.2	14.2	14.2
Quench air Temp (deg. c)	19	19	19
Quench air Humidity %	40.8	40.8	40.8
% Torque	70	70	
Nitrogen in Hoper	3	3	3
Need: polymer chips moisture	Yes		
Need: Free fall samples for FAV, COOH	Yes	Yes	Yes

Table 2-2

#3	#4	#5	#6	#7	#8
MBM 10% Lactam					
2.96	2.96	2.96	2.96	2.96	2.96
on	on	on	on	on	on
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
250	245	240	235	230	225
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
257	251	246	240	235	231
200	10	10	10	10	10
250	250	310	260	360	400
200	200	200	200	200	200
14 R					
.024 x 0.072					
1.16	1.16	1.16	1.16	1.16	1.16
19.8	19.8	19.8	19.7	19.7	19.7
2.97	2.97	2.97	2.97	2.97	2.97
STD SCREEN					
TBD	TBD	TBD	TBD	TBD	TBD
14.2	14.2	14.2	14.2	14.2	14.2
19	19	19	19	19	19
40.8	40.8	40.8	40.8	40.8	40.8
3	3	3	3	3	3
Yes	Yes	Yes	Yes	Yes	Yes

Table 3-1

Sample I.D.	#9	#10	#11
POLYMER TYPE	BHS	BHS 10% Lactam	BHS 10% Lactam
Feeder Setting	2.96	2.96	2.96
water on feeding zone	on	on	on
zone 1 Temp. (deg. c)	252	252	247
zone 2 Temp. (deg. c)	252	252	247
zone 3 Temp. (deg. c)	252	252	247
zone 4 Temp. (deg. c)	252	252	247
zone 5 Temp. (deg. c)	252	252	247
zone 6 Temp. (deg. c)	252	252	247
zone 7 Temp. (deg. c)	252	252	247
8 Connecting Plate Temp. (deg. c)	252	252	247
9 Block Temp. (deg. c)	252	252	247
10 Spin Pump Temp. (deg. c)	252	252	247
11 Top Cap (deg. c)	252	252	247
12 Spin Pack Temp. (deg. c)	252	252	247
Top Heated Sleeve Length (inches)	xxxx	xxxx	xxxx
Top Heated Sleeve Length (deg. c)	xxxx	xxxx	xxxx
Bottom Heated Sleeve Length (inches)	xxxx	xxxx	xxxx
Bottom Heated Sleeve Length (deg. c)	xxxx	xxxx	xxxx
Barrel Melt Temp (deg. c)	259	260	254
Melt Pump Inlet Pressure (psi)	40	90	250
Melt Pump Outlet Pressure (psi)	970	520	570
Extruder (rpm)	200	200	200
Spinneret: no. of holes / Shape	14 R	14 R	14 R
Spinneret: capillary diameter & depth	.024 x 0.072	.024 x 0.072	.024 x 0.072
Metering pump size (cc/rev)	1.16	1.16	1.16
Metering pump (rpm)	19.7	19.7	19.7
Thruput (lbs/hr)	2.97	2.97	2.97
Filter type	STD SCREEN	STD SCREEN	STD SCREEN
Monomer Exhaust Reading (inches water)	TBD	TBD	TBD
Quench air Flow rate (CF/M)	14.6	14.5	14.6
Quench air Temp (deg. c)	19.5	18.9	19.2
Quench air Humidity %	28.7	39.3	39.7
% Torque	42	27	29
Nitrogen in Hoper	3	3	3
Need: polymer chips moisture			
Need: Free fall samples for FAV, COOH			

Table 3-2

#12	#13	#14	#15	#16	#17
BHS 10% Lactam	BHS 10% Lactam	BHS 10% Lactam	BHS 10% Lactam	135	135 10% Lactam
2.96	2.96	2.96	2.96	2.96	2.96
on	on	on	on	on	on
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
242	237	232	227	260	260
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
xxxx	xxxx	xxxx	xxxx	xxxx	xxxx
249	245	240	235	270	269
280	180	50	70	1200	300
610	740	790	840	1600	1040
200	200	200	200	200	200
14 R	14 R	14 R	14 R	14 R	14 R
.024 x 0.072	.024 x 0.072	.024 x 0.072	.024 x 0.072	.024 x 0.072	.024 x 0.072
1.16	1.16	1.16	1.16	1.16	1.16
19.7	19.7	19.7	19.7	19.7	19.7
2.97	2.97	2.97	2.97	2.97	2.97
STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN	STD SCREEN
TBD	TBD	TBD			
14.9	15	14.6	14.9	14.5	15.1
19.2	18.7	19	19.4	18.5	19.2
41.6	39.7	40.3	39.4	39.6	41.1
30	29	30	29	56	37
3	3	3	3	3	3